

Date: Tuesday, 19/08/2008 4:07:27 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 41512-2
 Estimate Number : 13385
 P.O. Number :
 This Issue : 19/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 40244
 Written By :
 Checked & Approved By : JLD 08.8.20
 Comment : Est Rev:A 08-06-19 new issue DD verified by:ec
 Est Rev:B 08-06-27 procedure chg DD verified by:EC

Drawing Name : SUPPORT PLATE
 Part Number : PB674300171
 Drawing Number : B6743001 P.9/26
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 18/09/2008
 Qty: 30 Um: Each

split 20

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.8594 sf(s)/Unit Total: 25.7828 sf(s)
 6061-T6 .090 Sheet
 batch: 109124 IB 8-9-9

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001-159
 Dwg Rev: B1 IB 8-9-9
 Prog Rev: B1
 ****grain direction along 5.750" ****
 2-Deburr if necessary IB 8-9-9



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK
 POSITIVE RECALL
 EFFECTIVE 08.09.09 AUTH [Signature]



Comment: SECOND CHECK
 RELEASED [Signature] DATE 08.09.10

5.0 BRAKE NC NC BRAKE



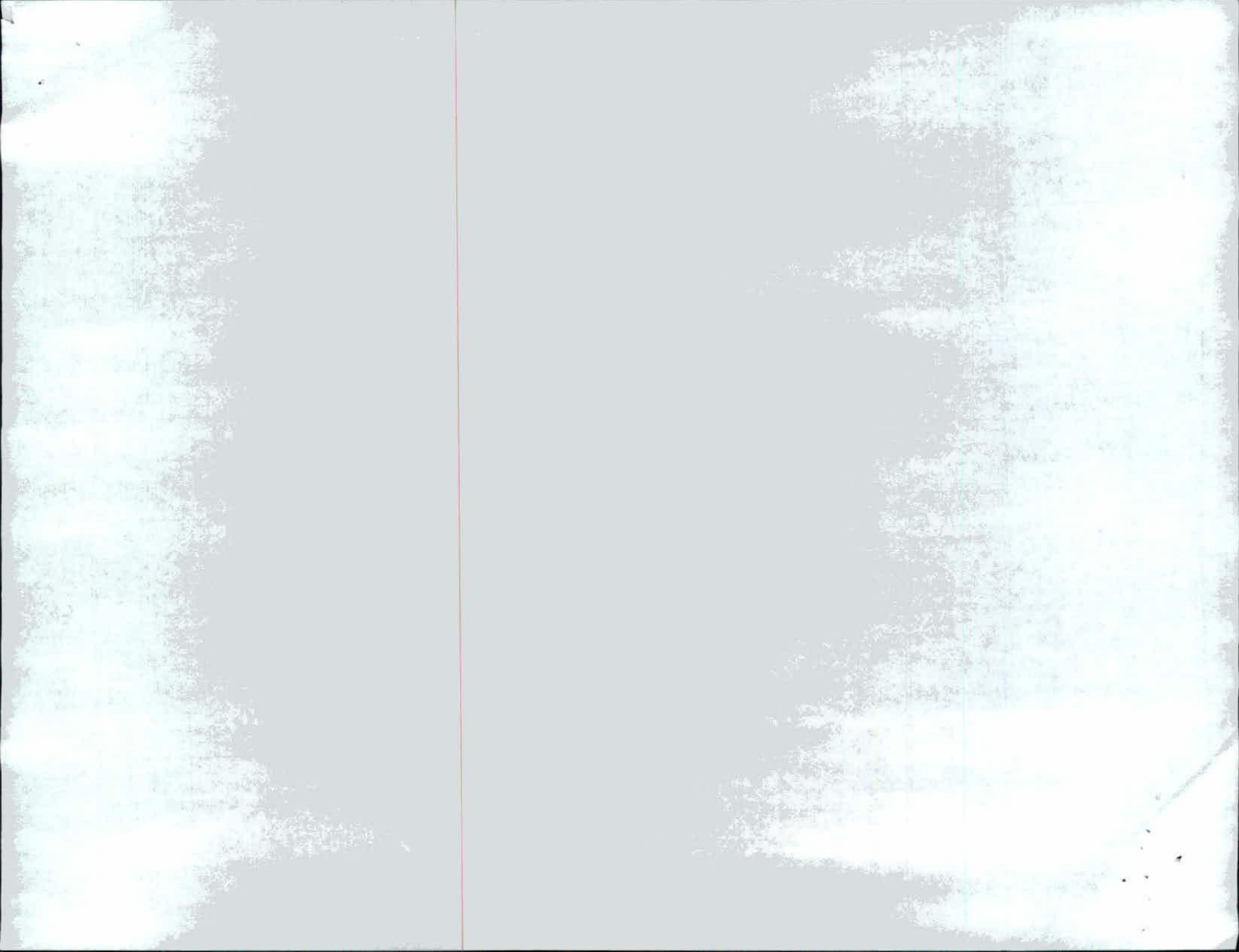
Comment: NC BRAKE 1- countersink as per dwg 08.09.10 (30)
 2-Bend as per Dwg B67-43001 08/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Appro' QC Insper

Part No: PB67-43001-71 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 28/12/12
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41512-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approva QC Inspecti
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
03/01/15	5	1 piece was was out of tolerance RC poor drawing	<i>[Signature]</i> 28/12/12	Scrap & destroy No Replue	<i>[Signature]</i> SB	<i>[Signature]</i> 08/01/16	<i>[Signature]</i> 28/12/12	<i>[Signature]</i> 08/01/16

NOTE: Date & initial all entries



Process Sheet

ner: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Number: 41512

Part Number: PB674300171

umber:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/02/16 (229) *caution*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1- weld as per dwg B67-43001

SP 08.12.16

(21x)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-grind weld flush

SP 08.12.16

(21x)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELLS

508/12/17 (20)

10.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

508/12/17 (21)

11.0

HAND FINISHING1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 085.4.1

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 180.0000 Each(s)
Nutplate

M109068 (26x) M10937 (100x) *ep08/12/18*

14.0

MS20426AD34



Comment: Qty.: 12.0000 Each(s)/Unit Total: 360.0000 Each(s)
RIVET

M105978 x 96mm

M105978 (252x) *ep08/12/18*

Process Sheet

ner: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Number: 41512

Part Number: PB674300171

Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-install nut plates as per dwg B67-43001

16.0

QC5

INSPECT WORK TO CUR



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 432

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

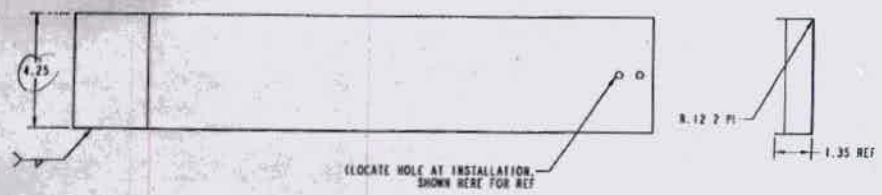
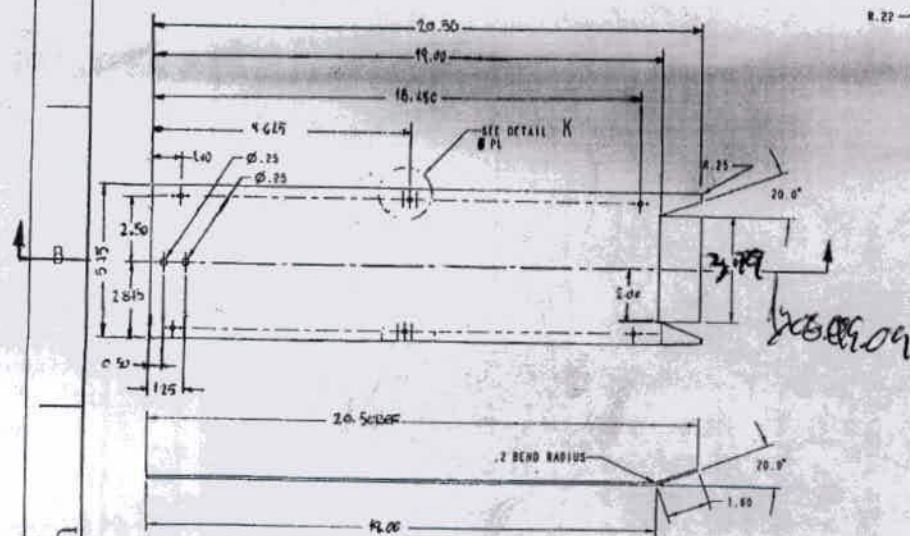
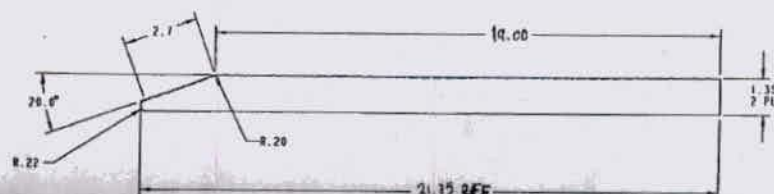
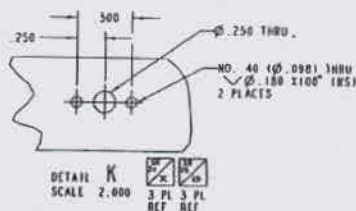
Job Completion



mf 08-12-79



RELEASED
46 of 20



② -73 20 DEGREE COVER PLATE
MATERIAL: .032 THK, 8061-T6, QQ-A-250/11
SCALE 0.500

② -159 SUPPORT PLATE
MATERIAL: .090 THK, 8061-T6, QQ-A-250/11
SCALE 0.500

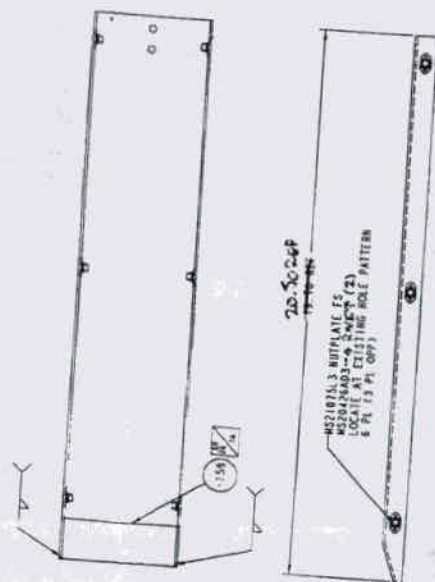
PART 13 SYMMETRICAL ABOUT CENTRAL LINE

PREMIER AVIATION, INC.
8801 Aviation Parkway, Grand Prairie, Texas 75050
D105UV8 B67-43001
SCALE: 1/16" = 1"

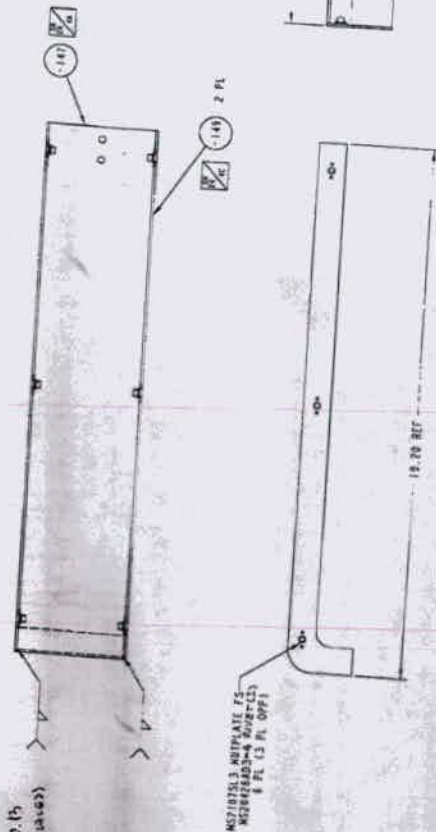
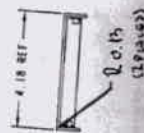
ORIGINAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ANY
WORK ORDER
WITHOUT NOTICE

RELEASED

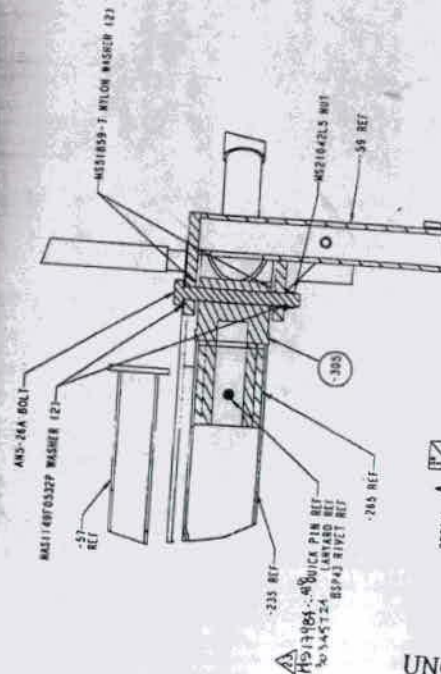


② 71 20 DEGREE BLADE SUPPORT ASSEMBLY ☒ 1% ☒ 1/2



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



DETAIL A
SCALE 0.750
(-03 ASSY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41512

PREMIER AVIATION, INC.
1000 American Parkway, Grand Prairie, Texas 75050

ORIGINAL

